



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-664-203
Job Sheet 196270



Part No: D412-664-203

Job Qty: 1 pcs

Part Name: Aft Crosstube - High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/19/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: D412-664-243 REV F/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat; Added D3189-1 K/DS IPP Rev:F 06-03-29 Remove Comments on Pick List JLM IPP Rev:G 06.12.08 per ECN 886 EC IPP Rev:H 07-04-30 As p Rev D JLM IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J 11.04.21 DEO D412-664 243-E-1 EC verified DD IPP REV:K 11.10.03 DEO D412-664-243-E-2 DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	7/19/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		

N/A
MAR-26-12

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D412-664-203/196270/5193848

				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120 Crosstubes - Bend - 2 - B4B	1 pcs	7/19/19	0.50 5.26	Crosstubes - Bend - B4B	BB 6/26/2019
130 QC 15	1 pcs	7/19/19	0.00 0.00	QC 15 - 12	
				QC 15 - 3	
				QC 15 - 47	
				QC 15 - 49	
				QC 15 - 58	
				QC 15 - 9	
140 Crosstubes - 2 - B4B	1 pcs	7/19/19	0.00 3.33	QC 15 - 68	DAS JUN 26 2019 68 9-89
				Crosstubes - 1 - B4B	BB 7/10/2019
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
160 Crosstubes - 3 - B4B	1 pcs	7/19/19	0.00 1.03	Crosstubes - 1 - B4B	BB 7/10/19
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
165 QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	DAS JUL 17 2019 40 9-89
				QC 7 - 24	
				QC 7 - 43	
170 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	DAS
			QC 5 - 30	40
			QC 5 - 40	17 2019 9-89
180 Outsource	1 pcs	7/19/19	SKY002-VC	5 JUN 2019 07-19
190 Packaging 2-1 - Receive - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 2 - 1 - B4B
			Packaging 2 - 2 - B4B	
			Packaging 2 - 3 - B4B	
			Packaging 2 - 5 - B4B	
			Packaging 2 - 4 - B4B	
			Packaging 2 - 6 - B4B	
			Packaging 2 - 7 - B4B	
			Packaging 2 - 8 - B4B	
			Packaging 2 - 9 - B4B	
			Packaging 2 - 10 - B4B	
			Packaging 2 - 11 - B4B	
			Packaging 2 - 12 - B4B	
			Packaging 2 - 13 - B4B	
			Packaging 2 - 14 - B4B	
			Packaging 2 - 15 - B4B	
			Packaging 2 - 16 - B4B	
			Packaging 2 - 17 - B4B	
			Packaging 2 - 18 - B4B	
			Packaging 2 - 19 - B4B	
			Packaging 2 - 20 - B4B	
			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	
			Packaging 2 - 26 - B4B	
			Packaging 2 - 27 - B4B	
			Packaging 2 - 28 - B4B	
			Packaging 2 - 29 - B4B	
			Packaging 2 - 30 - B4B	
			Packaging 2 - 31 - B4B	
			Packaging 2 - 32 - B4B	
			Packaging 2 - 33 - B4B	
			Packaging 2 - 34 - B4B	
			Packaging 2 - 35 - B4B	
			Packaging 2 - 36 - B4B	
200 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10
				QC 5 - 12
				QC 5 - 17
				QC 5 - 18
				QC 5 - 19
				QC 5 - 22
				QC 5 - 24
				QC 5 - 3
				QC 5 - 43
				QC 5 - 49
				QC 5 - 51

				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS 40
				QC 5 - 40	JUL 19 2019 9-89
210 Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 1.47	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 19-7-31
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
220 QC 14	1 pcs	7/19/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	DAS 68
				QC 14 - 40	AUG 07 2019 9-89
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
230 Crosstubes - 4 - B4B	1 pcs	7/19/19	0.00 3.33	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	RD 19-8-9
240 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS 40
				QC 5 - 40	AUG 16 2019 9-89
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	

					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	7/19/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
270 Packaging 3-1 - Stock - B4B	1 pcs	7/19/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	7/19/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
280 QC 21 - FG	1 pcs	7/19/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

AUG 26 2019

DAS 70 9-85 103

Part Op 110 - (Pick Kit)

Descriptions: 120 - CNC Alpha 160 Bender) Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and Folio FT010

130 - (QC15- Crosstube Dimensional Check)

140 - 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers. 2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-SCRIBE PART # & BATCH # ACCORDING TO NOTE 6

4- *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

160 - (Crosstubes Chemical Conversion) ***IMMEDIATELY AFTER GRINDING***

165 - (QC7-Inspect Chemical Conversion Coat)

170 - (QC5- Inspect part completeness to step on W/O) INSPECT ENGRAVING AND BATCH #

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - (Receive & Inspect for Damage & Mat'l Certs) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

Inspect for damage & ensure results are as per Dwg D412-664-203

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY BATCH # TO MATCH W/O

PRIMER: 5154177 START TIME: 2-Paint outside crosstube with White Imron as per DWG D412-664-243 and QSI 005 4.2 3- Apply clear coat after paint as per DWG

220 - (QC14- Inspect Spray Paint) Then, Wrap in plastic bag to protect from scratches

230 - Assemble as per Dwg D412-664-203 1- Install center support using scotch-weld DP460 per QSI 015, as per DWG. note 13. Install supports clamps using as per Dwg D412-644-243. Install clamp with rubber cushion as per DWG. note 14.

ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT Torque clamps on support to 80-100 IN-LBS AS PER DWG. EXP DATE: 8/20

2- **IF NOT ALREADY PRESENT ON CHAFFING SHEILD.** Apply a thin coat of proseal 890 per QSI 015 on inside concave surface of chaffing shield and let cure per manufacturer's instructions. Install prosealed chaffing shield onto crosstube by applying a thin coat of proseal 890 onto crosstube. Be sure to eliminate any air gaps. Install and torque clamps on chaffing shield to 40-50 IN-LBS AS PER DWG. EXP DATE: 10/20

AFTER FINISH CURE TIME 24H START CURE TIME: 10/20 FINISH CURE TIME: 11/9/25 exp 10/19

240 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 24HOURS AS PER DWG.***

250 - (Pick Kit)

260 - (QC4- 100% Inspect kits for completeness)

270 - (Identify as per dwg & Stock Location:) Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date ***** Time & date of packaging: Location:

275 - Photocopy bluefile and create labels as per PPP D412-664-203 CHG 010

280 - (QC21- Final Inspection - Work Order Release) 1- *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP TO LOCATE CENTER OF CROSSTUBE***** Install center support using scotch-weld DP460 per QSI 015, as per DWG. note 13. Install supports clamps using as per Dwg D412-644-243. Install clamp with rubber cushion as per DWG. note 14. ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG. 1- *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** Install center support using scotch-weld DP460 per QSI 015, as per DWG. note 13. Install supports clamps using as per Dwg D412-644-243. Install clamp with rubber cushion as per DWG. note 14. ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG.

011 450

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D412-664-203TRN	Crosstube Turning Detail	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5186421
D2896-1	Support	1 pcs (1 ea)	230-Crosstubes - 4 - B4B	
D3189-1	Chaffing Shield	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D3595-063-570	Rubber Cushion 0.63" Wide X 5.70" Long	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
MS21920-28	Clamp	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	
MS21920-30	Clamp	2 Ea (2 ea)	230-Crosstubes - 4 - B4B	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
AN6-41A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
	Nut	6 Ea (6 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0663J	Washer	18 Ea (18 ea)	250-Packaging 1-1 - Pick Kit - B4B	

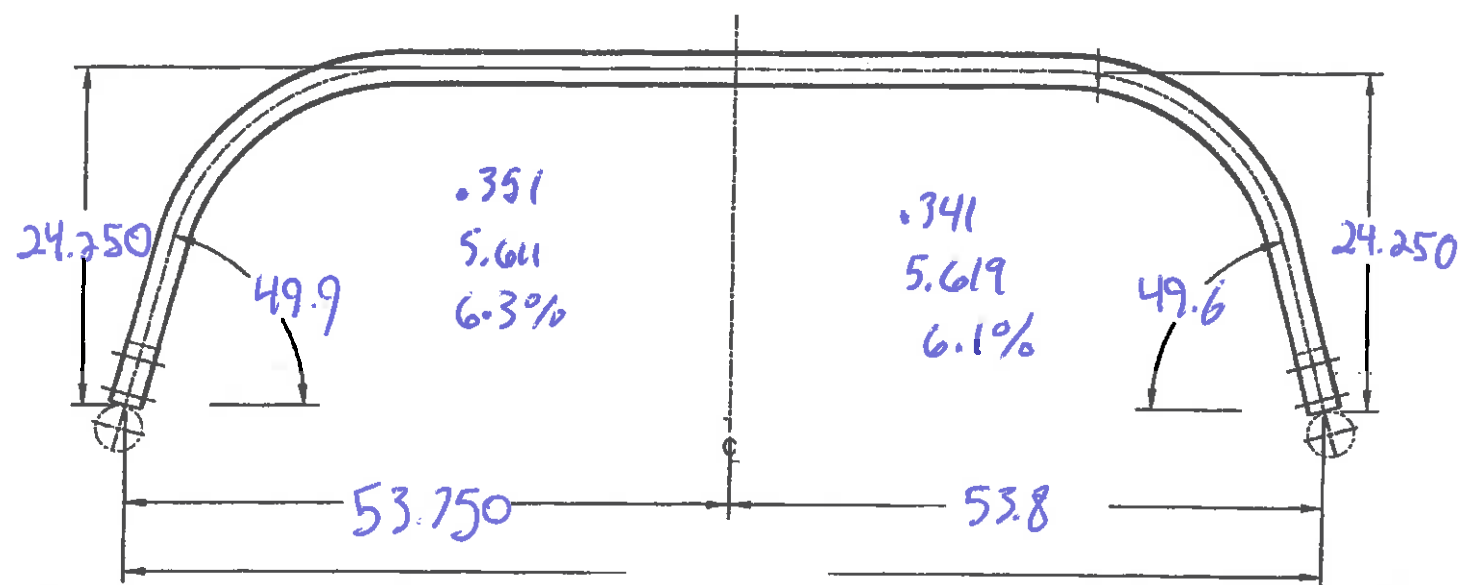
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit 230-Crosstubes - 4 - B4B	D412-664-203TRN	1	4	0
	D2896-1	① 5053883	15	0
	D3189-1	② 5175228	15	0
	D3595-063-570	② 5056672	93	0
	MS21920-28	④ 5171291	138	0
250-Packaging 1-1 - Pick Kit - B4B	MS21920-30	② 5162646	33	0
	AN6-40A	4	84	0
	AN6-41A	2	47	0
	MS21042L6	6	373	0
	NAS1149D0663J	18	882	0

Part Specifications	
Specifications could not be found.	

Plex 6/11/19 8:17 AM Dart.lajeunesse.marie

DART AEROSPACE LTD	Work Order:	196270
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: F		Page 1 of 1

Required Dimension	Min	Max
Height	24.12	24.62
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70
Bending Passes	8	--
Crushing	--	7%



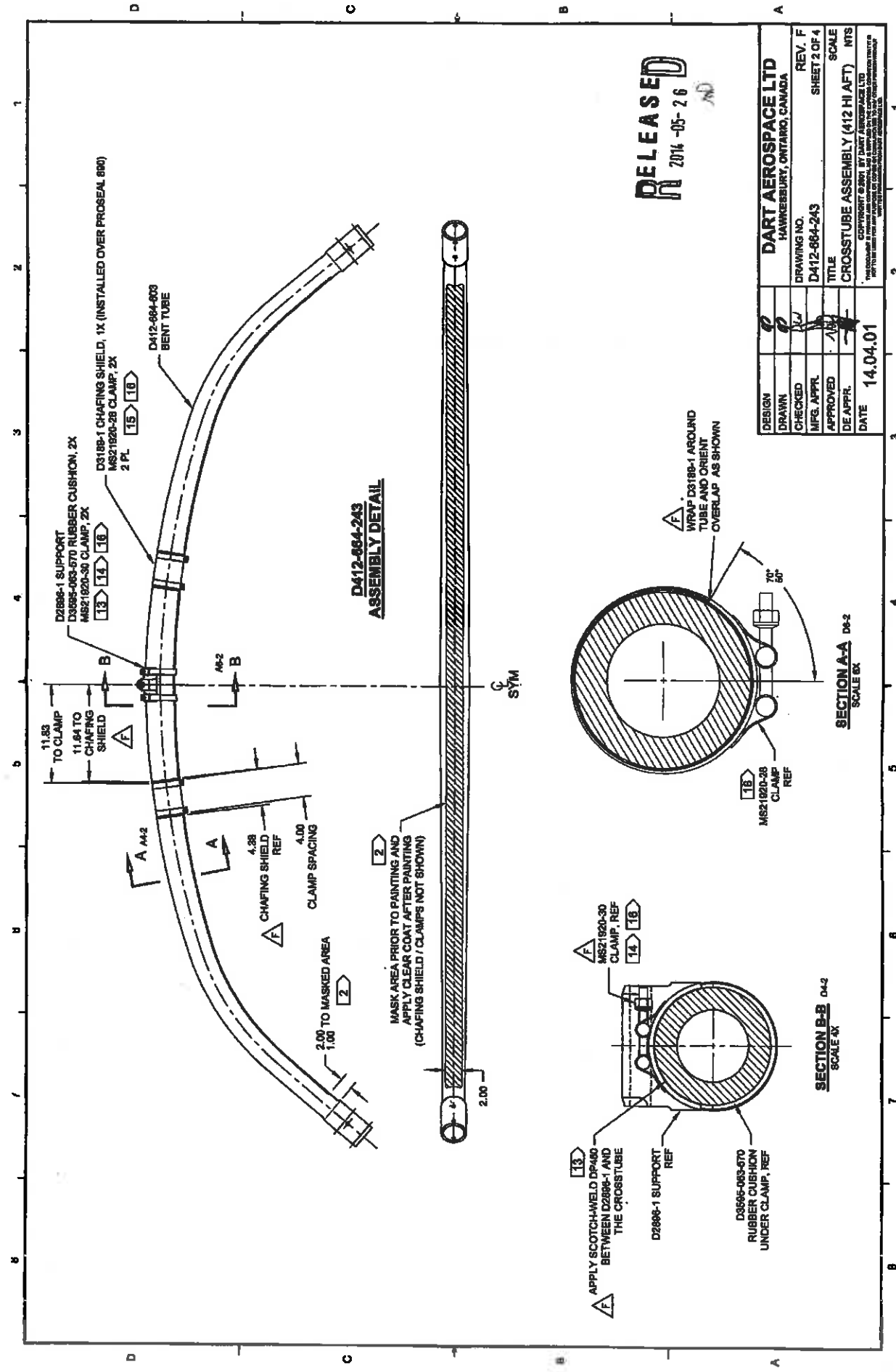
2.630
2.981

	Side A	Side B
Bending Passes		
Crushing	6.3%	6.1%
Comments		

2.639
2.980

QC15 Inspection	DAS 68
Date	JUN 26 2019

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.09.08	Max crushing % revised	KJ	





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044044



Supplier: SKY002-VC Skyservice 6120 Midfield Road Mississauga ON L5P 1B1 Canada Phone: 905-678-5636 Fax: 905-678-5841	PO No: POHB044044 PO Date: 7/18/19 Due Date: 7/19/19 Purchase Order Revision: Revision Date: Ship-To Contact: Phone:
Attention: Jenne, Heather	Via: Ground Pymt Terms: Net 30 Freight Terms: Special Comments:
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	

Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit	Price (CAD)	Extended Price
1	190568	D135-1027-253	Mid Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs		\$119.50
	190569		1 x JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs		\$119.50
Sub Total:							2	0	2			\$239.00
2	191905	D135-1027-251	Std Height Aft Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs		\$119.50
	191907		1 x JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs		\$119.50
Sub Total:							2	0	2			\$239.00
3	190576	D135-1027-151	Std Height Fwd Crosstube - DO NOT USE ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs		\$119.50
	190575		1 x JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs		\$119.50
Sub Total:							2	0	2			\$239.00



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044044



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194644	D412-664-203	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	194647		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196270		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196271		1 X JUL 19 2019	Firmed	-	7/19/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							4	0	4		\$478.00

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Grand Total: \$1,195.00

Order Notes

- Procurement Quality Clauses
- A005 right of entry
 - A012 chemical and physical test report
 - A016 personnel qualification
 - A017 raw material identification (as applicable)
 - A022 Apical Processing
 - A024 process certifications
 - A026 certification of material conformance
 - A041 quality management system
 - A042 dart notification by supplier
 - A043 retention of quality documents
 - A048 counterfeit parts avoidance, detection, mitigation and disposition program
 - A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 1:28 PM Dart.Guerin.Kimberley



skyservice

Work Order Traveler
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 365

WO #: MWO41122	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044044 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

DAS
40
9-89

- ✓ 4 AFT CROSSTUBES , P/N: D412-664-203 , J/S: 194644 , 194647 , 196270 , 196271
- ✓ 2 STD HEIGHT FWD CROSSTUBES , P/N: D135-1027-151 , J/S: 190575 , 190576
- ✓ 2 STD HEIGHT AFT CROSSTUBES , P/N: D135-1027-251 , J/S# 191905 , 191907
- ✓ 2 MID HEIGHT AFT CROSSTUBES , P/N: D135-1027-253 , J/S: 190568 , 190569

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						JUL 19 2019	 
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

RECEIVED
JUL 19 2019
DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JUL 19 2019
Name: RAFIK MELIKIAN		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>196270</u> Part No. <u>D412-664-203</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☒ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :		Sequence #:		QTY Affected :		MRB (OS1042) <u>NCR. 19, 08, 48</u>			
Description Work Order Deviation				Disposition					
Center support misalignment causes slight rocker beam to brush against side of chafing shield.				Contact within acceptable range. Within play of rocker beam jig					
Completed By <u>NC</u> - 19, 08, 10				Lead hand / Supervisor					
QC / QA Coordinator <u>68</u> 9-89									

Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Misaligned/off center ☐ Folio/Program ☐ BOM/Route ☐ Grain Direction ☐ Broken/Damage/Defect ☐ Weld ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Drill Holes ☐ Out of Sequence ☐ Fit/Function ☐ Off-set/Set-up ☐									
Other/Details:											